

Date: Wednesday, 9/27/2006 11:09:39 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-STEP LEG ASSEMBLY
Job Number	: 28738		
Estimate Number	: 10385	Part Number	: D3065041
P.O. Number	: <i>N/A</i>	Drawing Number	: D3065 REV B
This Issue	: 9/27/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: 9/27/2006	Drawing Revision	: B
Previous Run	: 27590	Material	: <i>N/A</i>
Written By	:	Due Date	: 10/10/2006
Checked & Approved By	:	Qty:	<i>55</i> Um: Each
Comment	: Est Rev: <i>C</i> 02.11.01 Incorporated D3066-1 IPP KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	28738A	STEP SPACER
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Comment: Sub-Component STEP SPACER  
 D3065-1 B *28738 A*

*55 mx**MF. 06-11-27*

2.0	28738B	STEP SPACER
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Comment: Sub-Component STEP SPACER  
 D3065-3 B *28738 B*

*55 mx**MF. 06-11-27*

3.0	28738C	STEP LEG
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Comment: Sub-Component STEP LEG  
 D3065-5 B *28738 C*

*110**MF. 06-11-27*

4.0	28738D	STEP SPACER
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Comment: Sub-Component STEP SPACER  
 D3065-7 B *28738 D*

*55**MF. 06-11-27*

5.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)  
 Rivet, Universal Head  
 Pick:

Qty	Part Number	Description
30	MS20470AD4-4	Rivet

Batch




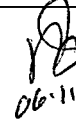
*m100993**- 700 mx.**MF. 06-11-27*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/27	6	1 part D3065-1 was snap hole was too open out of Tolerance		Scrap & destroy replace it	SES 06/11/27	 06/11/27	 06/11/27	 06/11/27

NOTE: Date & initial all entries

Date: Wednesday, 9/27/2006 11:09:39 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 28738

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

mf. 06-11-07

55

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/27

55

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 18, 19, 20, 21

06-12-4

55

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/06

55

Job Completion



06/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

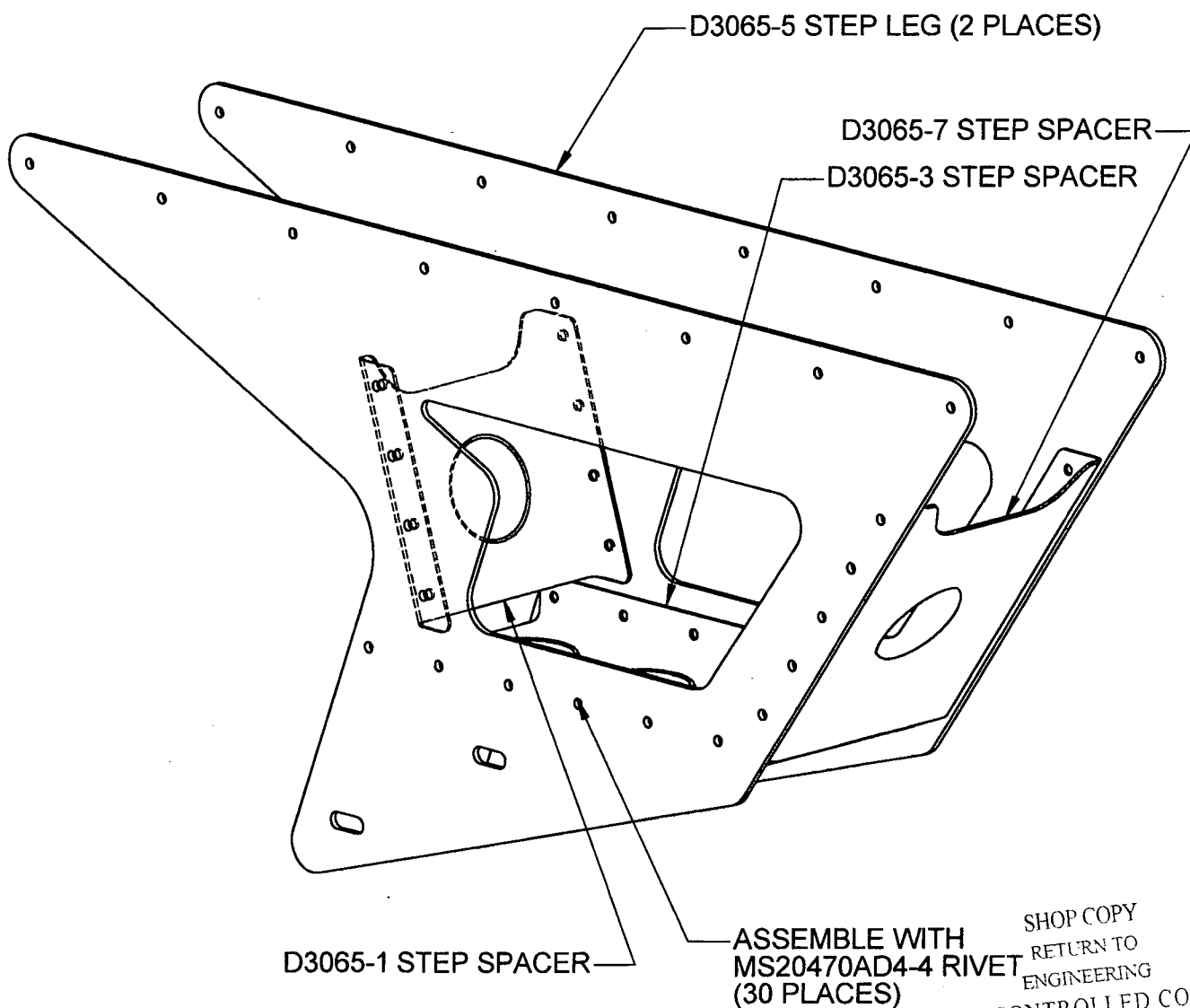
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



**D3065-041 STEP LEG ASSEMBLY**

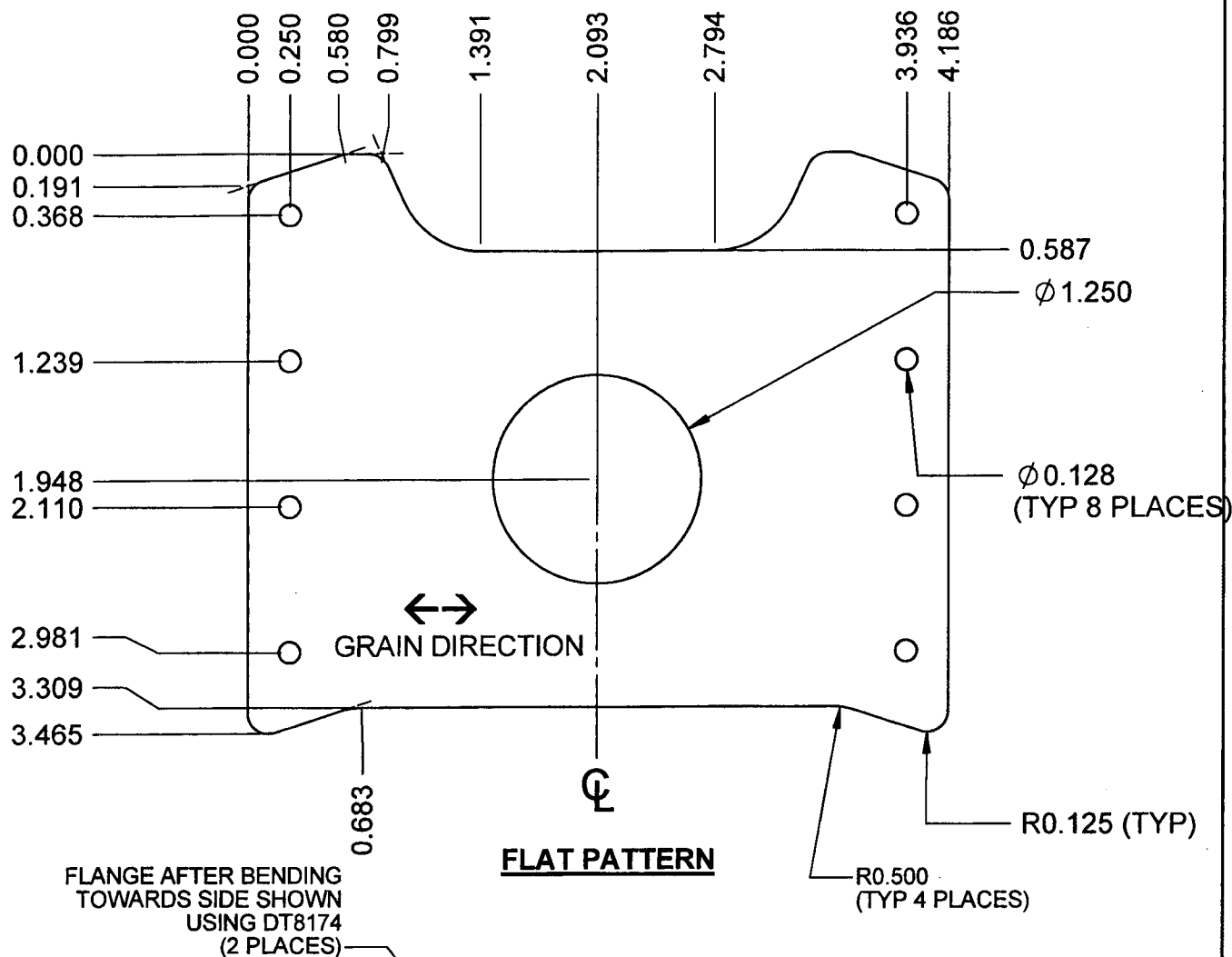
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WORK ORDER  
NO. **28738**

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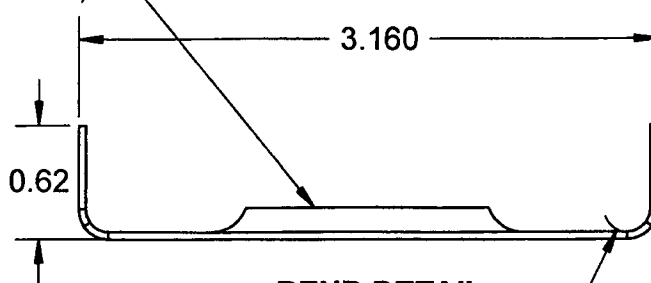
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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



**RELEASED**  
*[Signature]*



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

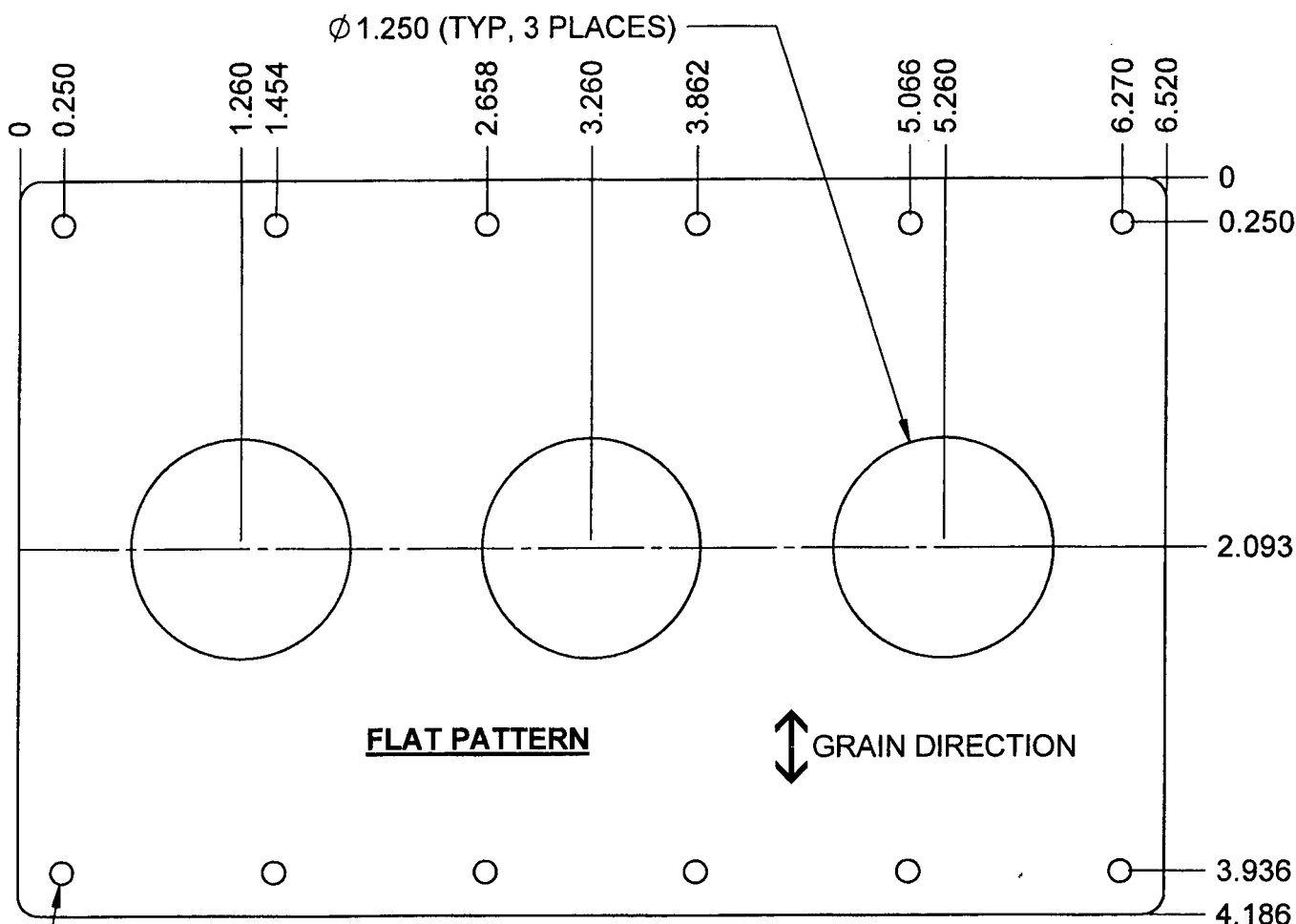
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

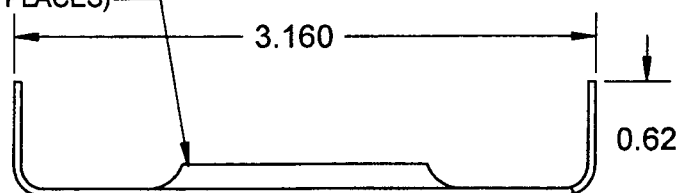


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

*06 Oct 20*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

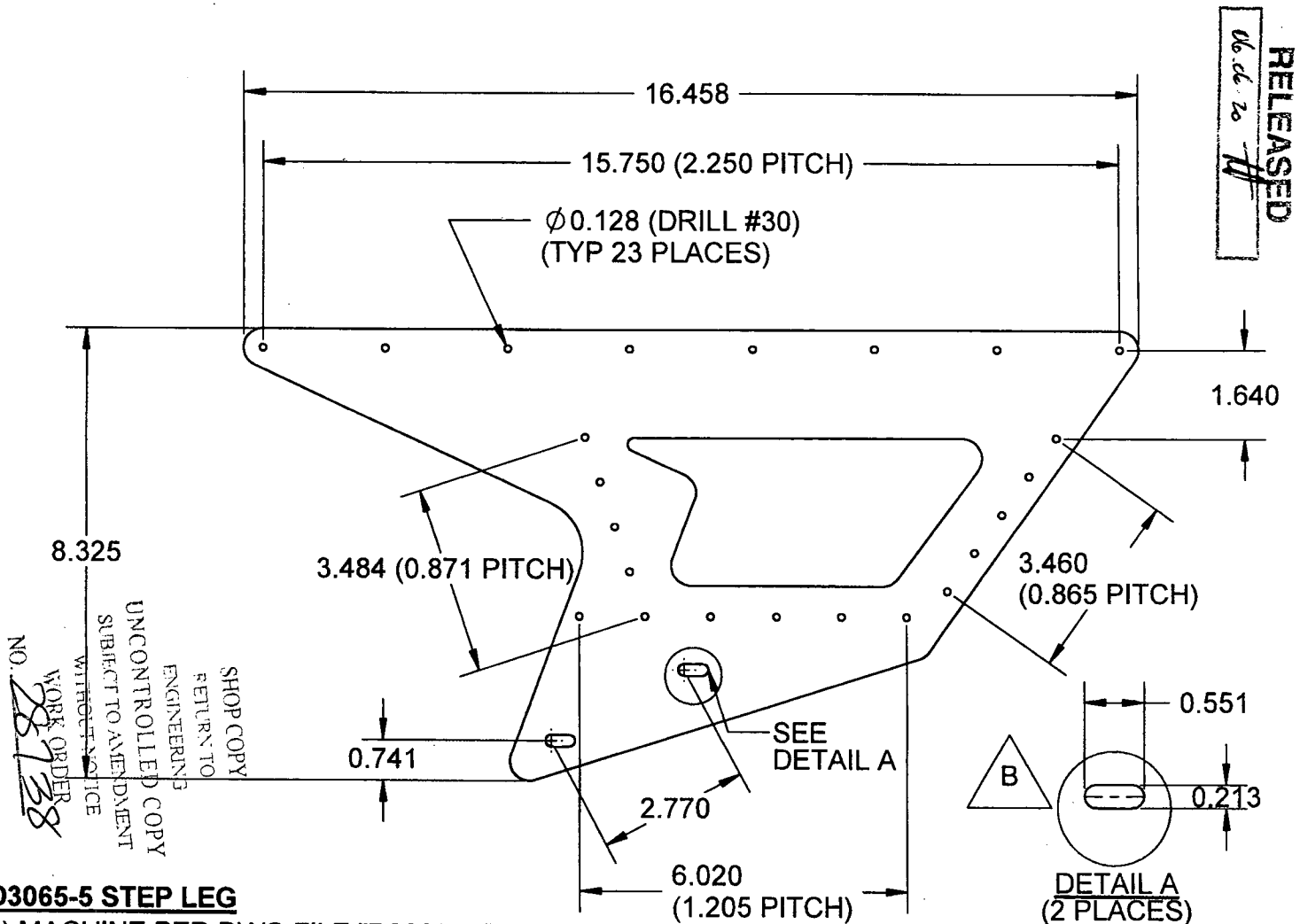
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CHECKED	<i>PH</i>	APPROVED	<i>CB</i>	DRAWING NO.
				<b>D3065</b>
DATE	06.05.23	TITLE		REV. B
		<b>STEP LEG ASSEMBLY</b>		SHEET 4 OF 5
			SCALE	1:3



**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

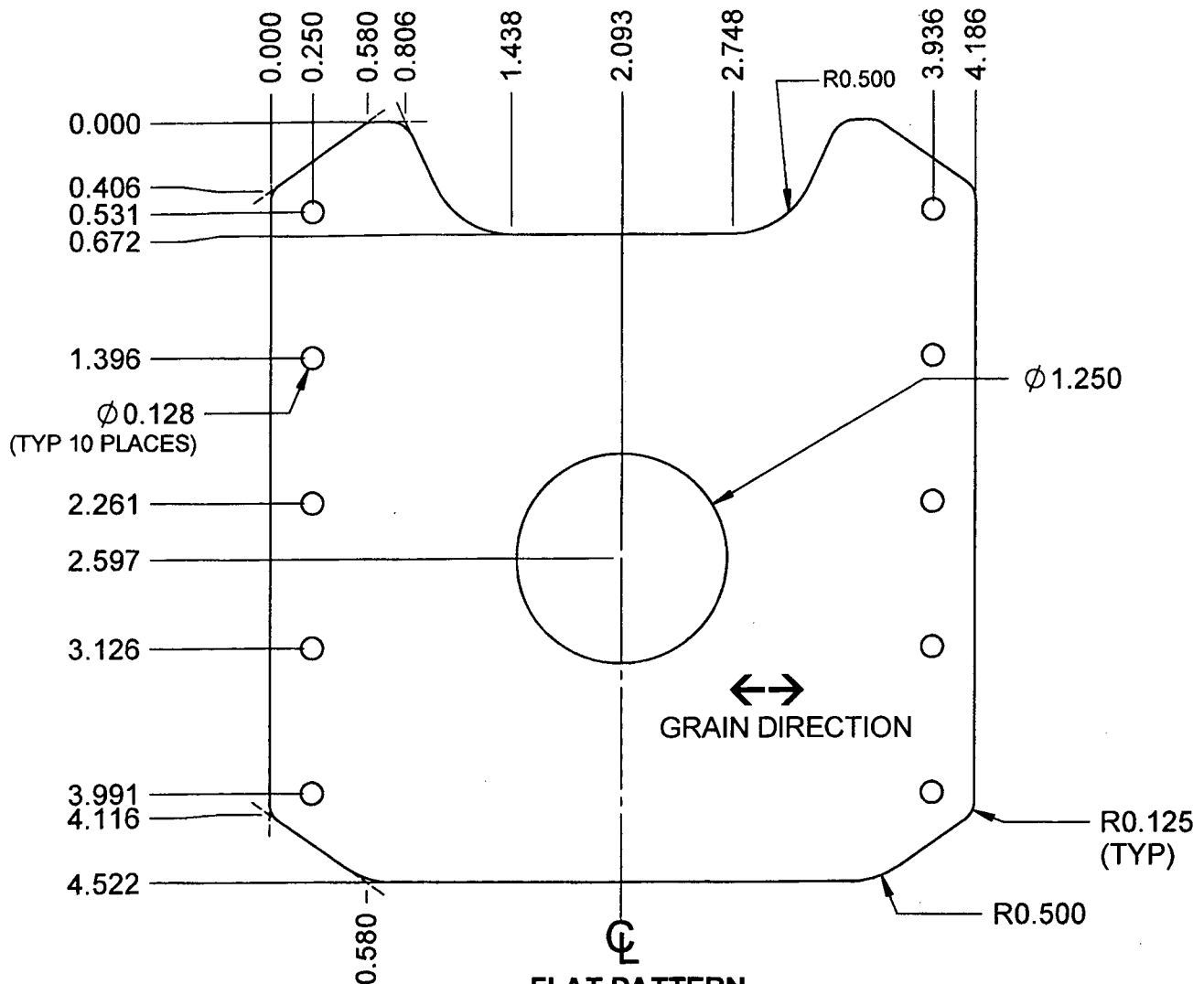
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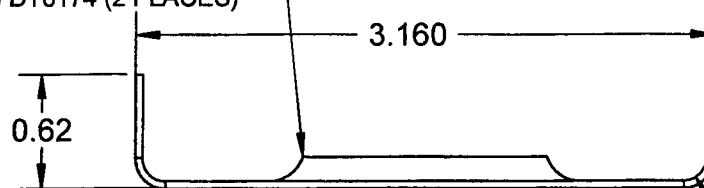
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DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)

**FLAT PATTERN**



**BEND DETAIL**

**RELEASED**

*de de re*

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NO. **28738**

### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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